



CEWELD ER 383

TYPE	ER 385 Stainless steel Mag welding wire for the GMAW process																					
ANWENDUNGEN	Tanks and process vessels, Piping systems, agitators, rotors, cast pumps and valves for use in the fertilizer, phosphoric, sulphuric and acetic acid plants																					
EIGENSCHAFTEN	ER 383 is used to weld base metals of similar composition to itself or to other grades of stainless steel. ER383 contains a low maximum of carbon, silicon, and sulfur to decrease the hot cracking and fissuring, while maintaining the resistance to corrosion.																					
KLASSIFIKATION	AWS	A 5.9: ER383																				
	EN ISO	14343-A: G 27 31 4 Cu L																				
	W.Nr.	1.4563																				
	F-nr	6																				
	FM	5																				
GEEIGNET FÜR	Alloy 825 N08825 , Alloy 825 h Mo N08821, Alloy 28 and Alloy 20 (X1NiCrMoCu31-27-4), Alloy 904L (X1NiCrMoCu25-20-5), 1.4563, 1.4539, NiCr 21 Mo 2.4858, NiCr 21 Mo 6Cu 2.6410, X3NiCrCuMoTi27-23 1.4503																					
ZULASSUNGEN	CE																					
SCHWEISSPOSITIONEN																						
TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>N</th> <th>Cu</th> </tr> </thead> <tbody> <tr> <td>0.02</td> <td>0.4</td> <td>1.55</td> <td>0.017</td> <td>0.01</td> <td>28.2</td> <td>32.1</td> <td>3.9</td> <td>0.05</td> <td>0.95</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	Mo	N	Cu	0.02	0.4	1.55	0.017	0.01	28.2	32.1	3.9	0.05	0.95	
C	Si	Mn	P	S	Cr	Ni	Mo	N	Cu													
0.02	0.4	1.55	0.017	0.01	28.2	32.1	3.9	0.05	0.95													
MECHANISCHE GÜTEWERTE	<table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{p0,2} (MPa)</th> <th rowspan="2">R_m (MPa)</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th colspan="2">RT</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>380</td> <td>570</td> <td>38</td> <td colspan="2">100</td> <td>HRc</td> </tr> </tbody> </table>	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness	RT		As Welded	380	570	38	100		HRc					
Heat Treatment	R _{p0,2} (MPa)					R _m (MPa)	A ₅ (%)		Impact Energy (J) ISO-V		Hardness											
		RT																				
As Welded	380	570	38	100		HRc																
RÜCKTROCKNUNG	Not required																					
GAS ACC. EN ISO 14175	I1, M21, I3																					